

Work Order ID 64028

Tuesday, November 23, 2010 8:06:37 AM



Page 1

Item ID:	D3914-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Long Basket Lid Assembly (350)				Stop	
Start Date:	11/23/2010	Start Qty: 1.00				
Required Date:	11/30/2010	Req'd Qty: 1.00				
Reference:						

Approvals:	Process Plan:		Date:	10-11-23	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3914	B

100 Weld per dwg A/R S.S. rod Batch: 1114649 0.00
Large Fab

Large Fab

Memo 0.00

1- assemble ribs , weld as per dwg D3914 using DT9607A
2- weld hinge (3) and Mounting brackets as per dwg D3914
inspect before welding mesh
3- tack weld mesh on basket as per dwg D3914
***make sure to place mesh correctly on lid, check with label plate before
tacking mesh***

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
QC
Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____







NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries




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Page 2

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Required Date: 11/30/2010 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 8 10/12/20 0.00				④			
130  Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 Memo *** mask sides of hinge prior to powdercoat*** Start Time: 11:00 Oven Temperature: 320° Finish Time: 12:00	0.00 0.00				1	162	10-12-20	
140  HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch M115790 Memo 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install placard and label as per dwg	0.00 0.00				27	10/12/20	1	16

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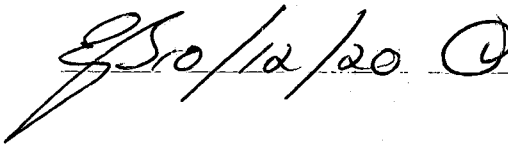

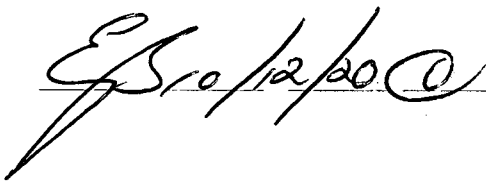

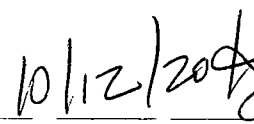
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
160  Packaging Packaging	Identify as per dwg & Stock Location: <i>GA</i> Memo <i>w/o 64024</i>	0.00 0.00							
170  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							 <i>mr</i> <i>10-12-20</i>

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Tuesday, November 23, 2010 8:06:42 AM

Parent Item Name: Long Basket Lid Assembly (350;

Required Date: 11/30/2010

Required Qty: 1.00

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2581  Mounting Bracket		Manufactured	No			100	Each	31.0000	2	2		10/12/16	
				<u>Location</u>				<u>Loc Qty</u>					
				WA				31					
					61953			20			2x		
					63493			11					
D3914-1  Rib		Manufactured	No			100	Each	4.0000	2	2		10/12/16	
				<u>Location</u>				<u>Loc Qty</u>					
				WA				4					
					63609			4			2x		
D3914-7  Rib		Manufactured	No			100	Each	4.0000	2	2		10/12/16	
				<u>Location</u>				<u>Loc Qty</u>					
				WA				4					
					63631			4			2x		
D4016-3  Hinge Half, Lid		Manufactured	No			100	Each	4.0000	3	3		10/12	
				<u>Location</u>				<u>Loc Qty</u>					
				WA				4					
					63256			4			1x		

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NOTE: Date & initial all entries

Picklist Print

Tuesday, November 23, 2010 8:06:42 AM

Page 2

Work Order ID: 64028

Parent Item: D3914-041






Parent Item Name: Long Basket Lid Assembly (35'

Start Date: 11/23/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

✓	D4018-5	Manufactured	No	100	Each	33.0000	9	9		
										
	Rib									
		<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
		WA			33					
		63610			33					
✓	D4020-5	Manufactured	No	100	Each	1.0000	1	1		
										
	Mesh (350 Basket Long, Lid)									
		<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
		WA			1					
		60643			1					
✓	D4021-3	Manufactured	No	100	Each	1.0000	1	1		
										
	Data Plate									
		<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
		WA			1					
		56050			1					
✓	D4035-041	Manufactured	No	100	Each	1.0000	1	1		
										
	Lid Rib Assembly, Fwd (350 Basket)									
		<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
		WA			1					
		61066			1					
✓	D4035-043	Manufactured	No	100	Each	1.0000	1	1		
										
	Lid Rib Assembly, Aft (350 Basket)									
		<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
		WA			1					
		61067			1					

10/12/16

9x
B63684 1x 10/12/16

B63611 1x 10/12/16

B63612 1x 10/12/16

B63613 1x 10/12/16

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 3

Work Order ID: 64028



Parent Item: D3914-041



Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 11/23/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

D2728-3

Manufactured

No

140

Each

0.0000

1

1



Dart Logo label



115050 *CV*

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

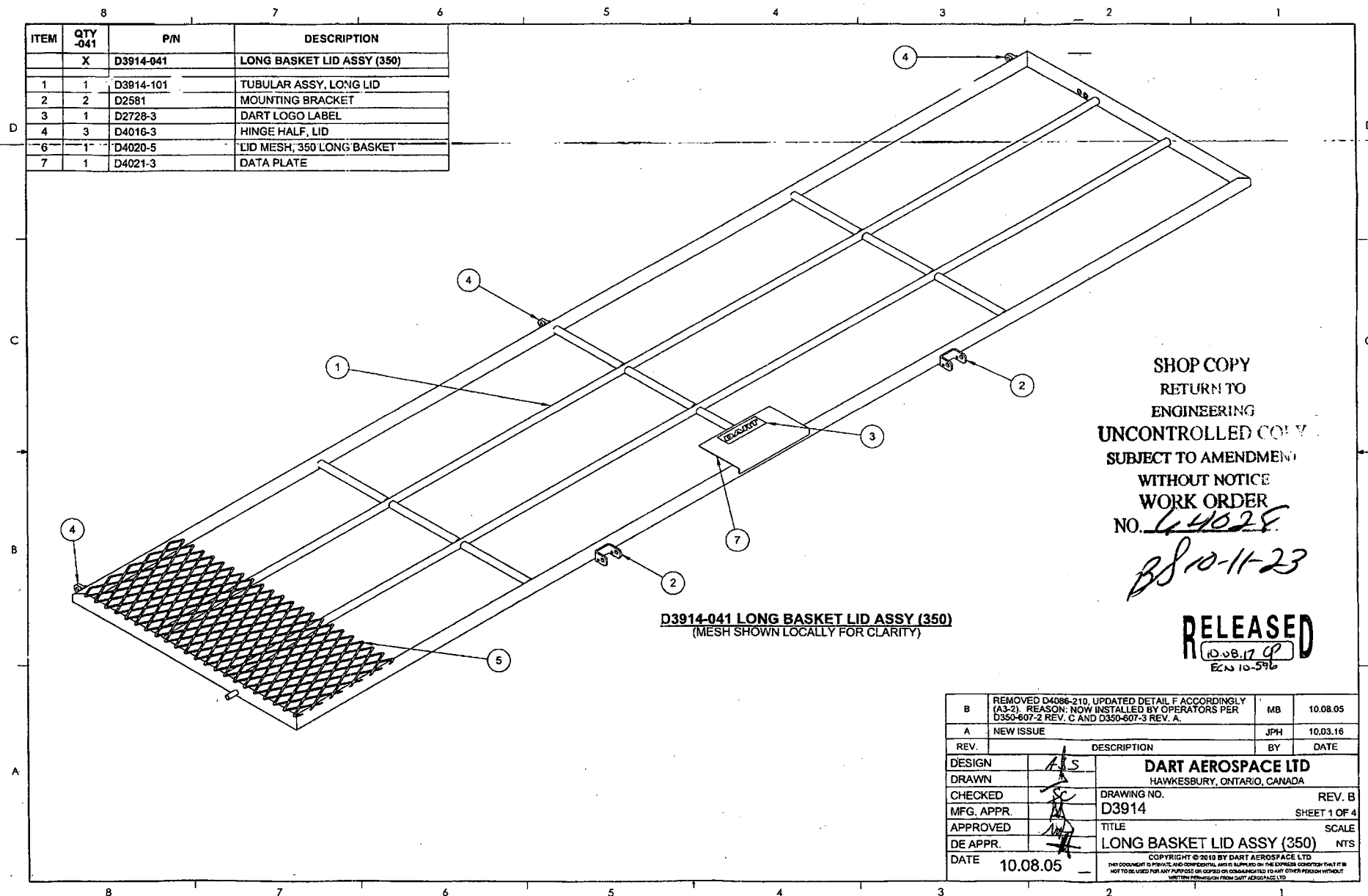
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 64028

BS 10-11-23

RELEASED
10.08.17
ECN 10-596

B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2) REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>ALS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>SC</i>		
CHECKED	<i>SC</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>SC</i>	D3914	SHEET 1 OF 4
APPROVED	<i>SC</i>	TITLE	SCALE
DE APPR.	<i>SC</i>	LONG BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED BY THE COMPANY HEREON THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

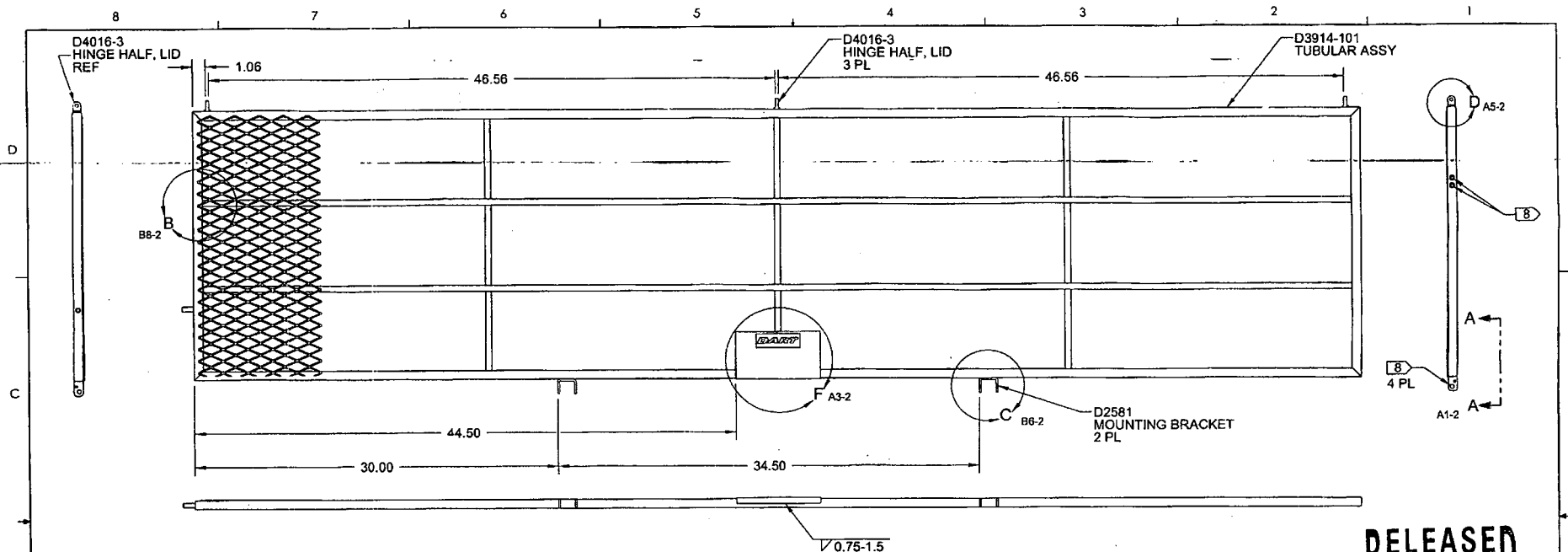
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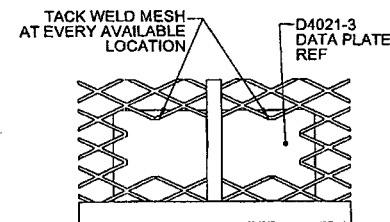
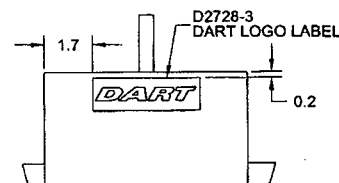
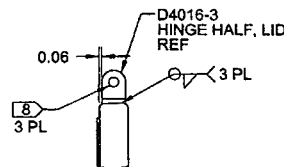
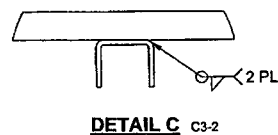
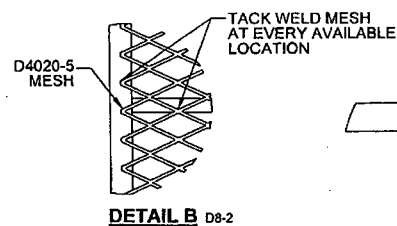
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D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

DESIGN	A/S	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	SC	D3914	SHEET 2 OF 4
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	LONG BASKET LID ASSY (350) NTS	
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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u/b Q4025

W/O:		WORK ORDER CHANGES					
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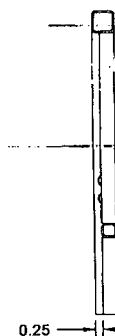
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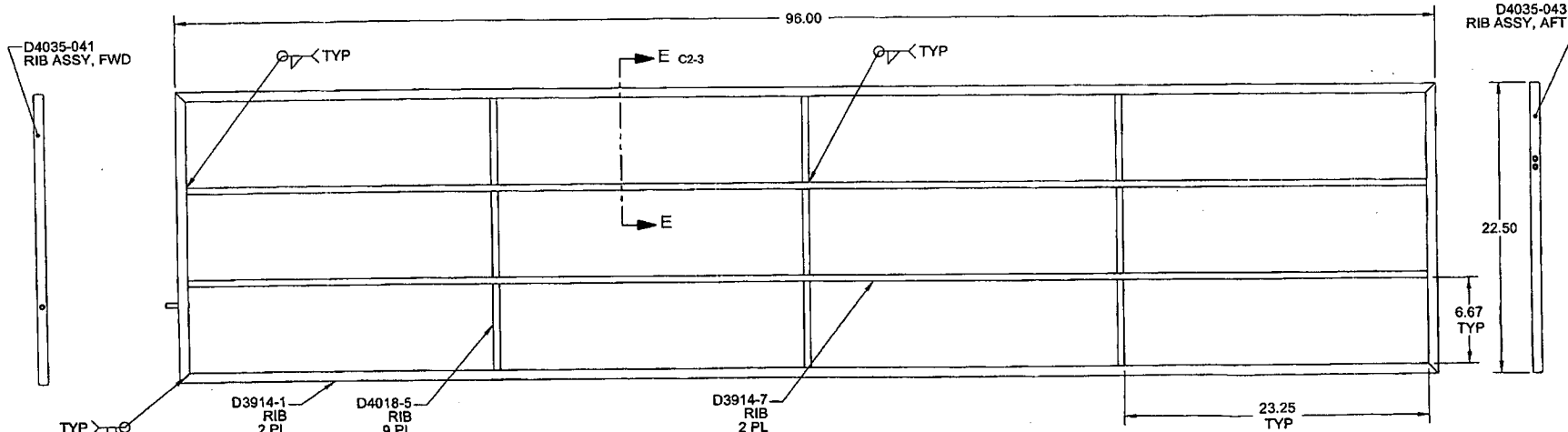
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E CS-3



B D3914-101 TUBULAR ASSY, LONG LID

RELEASED
10-08-05

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 14.10 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
 - 9) WELD PER DART QSI 004

Handwritten: w/o 64028

DESIGN	ALS	DART AEROSPACE LTD	REV. B
DRAWN	RC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RC	DRAWING NO. D3914	SHEET 3 OF 4
MFG. APPR.	MP	TITLE	SCALE
APPROVED	MP	LONG BASKET LID ASSY (350)	NTS
DE APPR.	MP	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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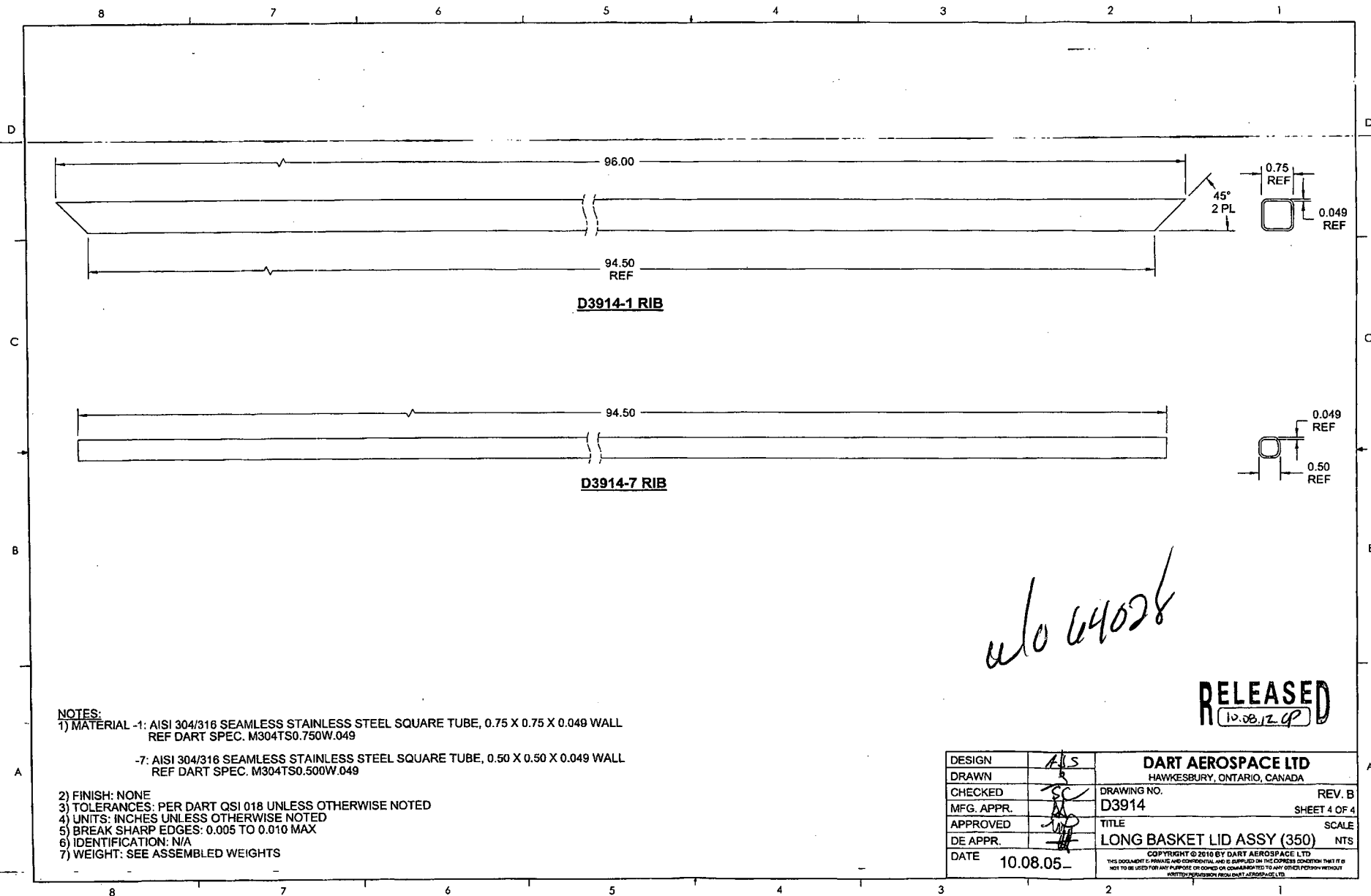
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